

Work Order ID 96267

January-21-13 2:57:51 PM

96267

Page 1

Item ID: D2873-045

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Nut Plate Assembly

Start Date: 1/21/13 Start Qty: ~~40.00~~ ²⁰

40

Cust Item ID:

Required Date: 2/04/13 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: MLS Date: 13-01-21 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2873	Rev A

100

100

BAND SAW

0.00

Bandsaw

Memo

0.00

20 13/01/13

24 0

Jeaspa Bandsaw

Cut blanks: 1.000" x 0.375" x 2.700" long

110

110

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

21

DAS 25 13-02-02

HAAS CNC vertical machine #1

Machine as per Folio FA and Dwg D2873 Identify as D2873-5
Dwg Rev A F1819Folio Rev AA

120

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

21

DAS 25 13-02-02

Quality Control

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N9000040100

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Revision ID:

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Stop *NS2*

Start Date: 1/21/13 Start Qty: 40.00

40

Cust Item ID:

Required Date: 2/04/13 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		ork 13/02/04		21	0		
140 *140* Small Fab Small Fab Small Fab	Small Fab Memo 1-Deburr 2- C'sink as per Dwg D2873	0.00 0.00				21			13/02/08
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		DAS 15 9-00 B2S		21			

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40

Cust Item ID:

Required Date: 2/04/13 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Small Fab	0.00							
180									
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per Dwg D2873 2-Identify as D2873-045								

21 76 13-2-13

21X

EP 13/03/05

21X

EP 13/03/05

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Required Date: 2/04/13 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: LG-050	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

(2) 13-03-05 89

21x 13-3-8

MLJ 13-03-08
MLJ 13-03-08

Picklist Print

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Page 1

Work Order ID: 96267

Parent Item: D2873-045

Parent Item Name: Nut Plate Assembly

96267

D2873-045

Start Date: 1/21/13

Required Date: 2/04/13

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21075L5

Purchased

No

100

Each

16.0000

2

80

MS21075L5

Nut Plate

**

Location

Loc Qty

Loc Code

ST318

16

123346

16

M6061T6B0.375X01.00
0

Purchased

No

180

f

1.3510

0.225

9.473684

M6061T6B0.375X01.000

6061T6.BAR .375 x 1.00

**

Location

Loc Qty

Loc Code

MAT002

1.35095

1.35095

MS20426AD4-6

Purchased

No

180

Each

1,666.000

4

160

MS20426AD4-6

Rivet

**

Location

Loc Qty

Loc Code

GA

1365

122814

1365

ST334

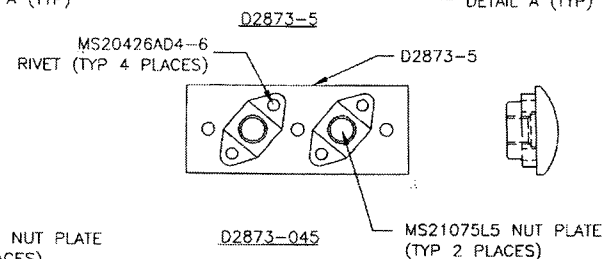
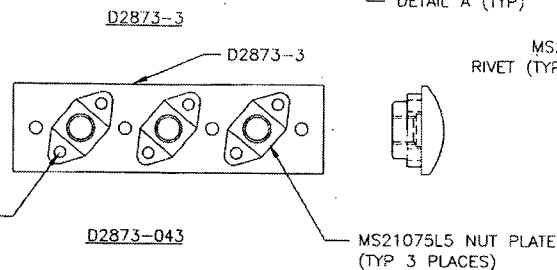
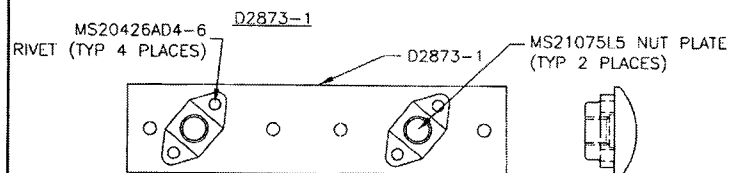
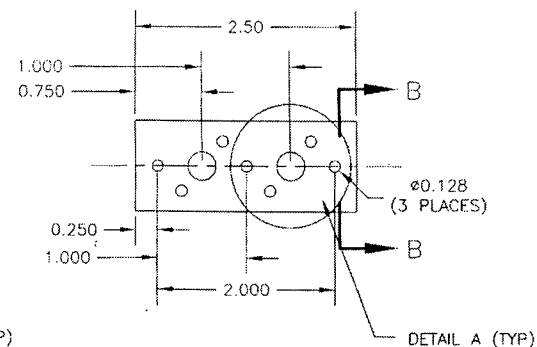
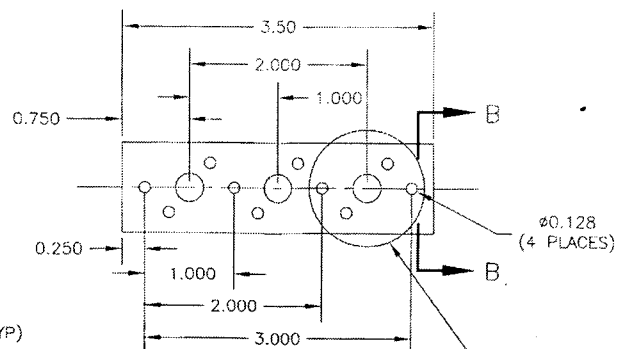
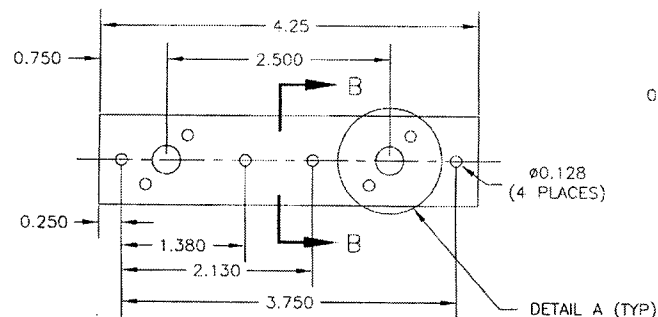
301

121708

301

EP 13/03/05
M124777 (42x)

RD 13/01/31
5.8
EP 13/03/05
~~160~~ 84



D2873-1/-3/-5 RADIUS BLOCK

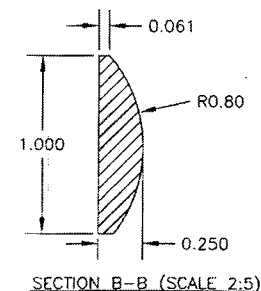
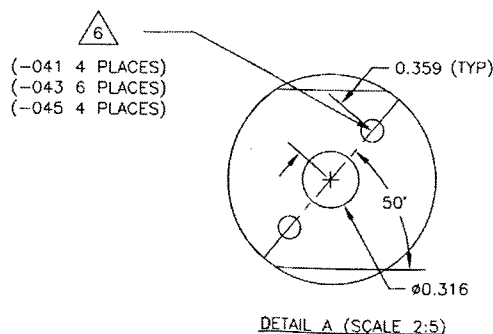
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) $\varnothing 0.128$ PILOT + C'BORE CURVED SIDE $\varnothing 0.230 \times 0.125$ DEEP + C'SINK CURVED SIDE $\varnothing 0.225 \times 100$

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1 SCALE 4:5

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UNCO
STW

96267 MLC
13-01-21

RELEASED
05-11-26